

Work Order ID 80408

80408

Page 1

February-21-12 9:06:28 AM

Item ID: D3650-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Center Panel

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/02/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3650

Rev C

SCRAP

100

100

Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3650

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

12-03-07 (2)

12-03-07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 06/03/2012 Req'd Qty: 2.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3650 using DT9426

2-bend as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Sup old rev
w
12/21/17

(72)

SR
12/21/17

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Page 3

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Revision ID:

Stop ***NS2***

Item Name: Center Panel

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-trim to fit (D3650-11)								
	2-Weld assembly as per dwg D3650 QSI004								
	3-grind weld smooth if necessary								
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

1/20/17

W/O:		WORK ORDER CHANGES					
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February-21-12 9:06:28 AM

N900040100

Setup Start *NS1*

Stop *NS2*

2

2

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

190 Identify as per dwg & Stock Location:

0.00

190

Packaging

Memo

0.00

Packaging

200 QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February-21-12 9:06:31 AM

Page 1

Work Order ID: 80408

80408

Parent Item: D3650-3

D3650-3

Parent Item Name: Center Panel

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3650-11		Manufactured	No			160	Each	5.0000	1	2			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3650-11

Filler Plate

**

Location

Loc Qty

Loc Code

WA021

5

45721

5

M304S26GA

Purchased

No

160

sf

94.8000

1.145

2.410526

M304S26GA

304/316 0.018 SHEET

**

12.03.07

Location

Loc Qty

Loc Code

MAT020

94.8

117798

94.8

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DART AEROSPACE LTD		Work Order:	80408
Description: Center Panel		Part Number:	D3650-3
Inspection Dwg: D3650	Rev: <i>EC</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	0.221	✓		Vern	HB-02
Ø0.213	+0.005/-0.001	0.214	✓		V-W ✓	" "
0.40	+/-0.030	0.405	✓		Vern	" "
15.45	+/-0.030	15.45	✓		Vern	" "
10.49	+/-0.030	10.49	✓		M.T	HB-01
15.53	+/-0.030	15.53	✓		M.T	" "
11.99	+/-0.030	11.99	✓		M.T	" "
12.90	+/-0.030	12.90	✓		M.T	" "
4.300	+/-0.010	4.300	✓		Vern	HB-02
12.09	+/-0.030	12.09	✓		M.T	HB-01
13.06	+/-0.030	13.06	✓		M.T	" "
1.943	+/-0.010	1.945	✓		Vern	HB-02
5.884	+/-0.010	5.889	✓		Vern	" "
8.248	+/-0.010	8.248	✓		M.T	HB-01
9.196	+/-0.010	9.196	✓		M.T	" "
13.80	+/-0.030	13.80	✓		M.T	" "
2.28	+/-0.030	2.30	✓		Vern	HB-02
7.19	+/-0.030	7.20	✓		Vern	" "
9.55	+/-0.030	9.55	✓		Vern	Proj-W-5-02
10.65	+/-0.030	10.65	✓		M.T	HB-01
3.35	+/-0.030	3.35	✓		M.T	" "

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12.03.07	Date: 12/13/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

.106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

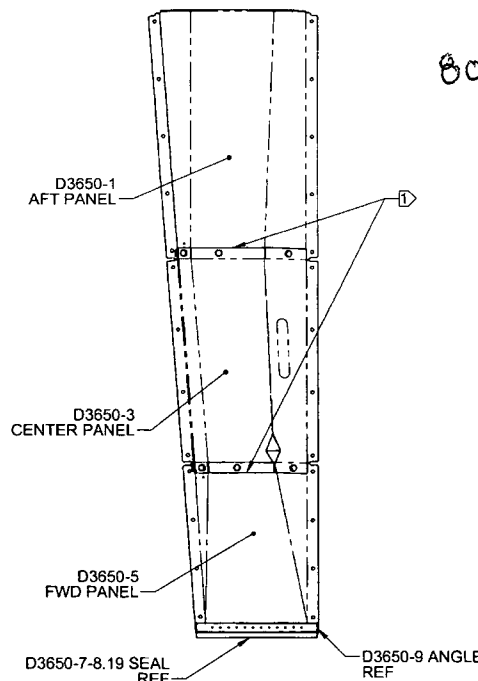
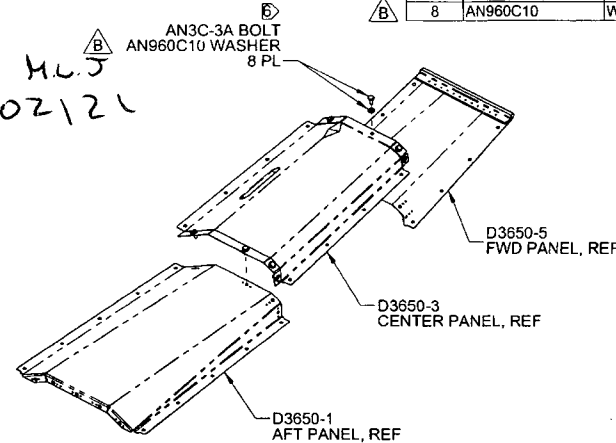
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

80408 H.L.J
12/02/21



D3650-041 TUNNEL TOP PANEL ASSEMBLY

DEO ATTACHED

UNDER REVIEW

RELEASE

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7, B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O: D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	1:8
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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NOTE: Date & initial all entries

80408

8

7

6

5

4

3

2

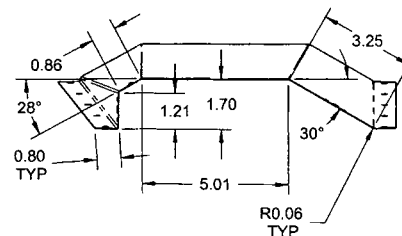
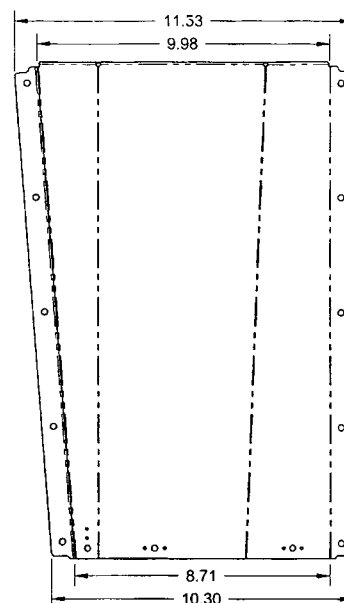
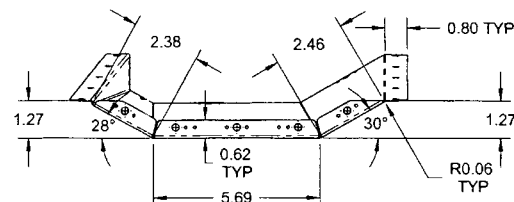
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MS21060-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
6 PL

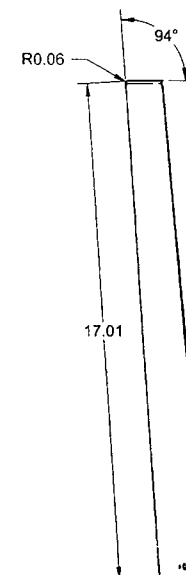
D3650-1B
AFT PANEL BENT PART

MS21062-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
3 PL

D3650-1 AFT PANEL



QTY	PART NUMBER	DESCRIPTION
-1		
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



DEO ATTACHED

UNDER REVIEW

RELEASED

D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3650	REV. C
MFG. APPR.			SHEET 2 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

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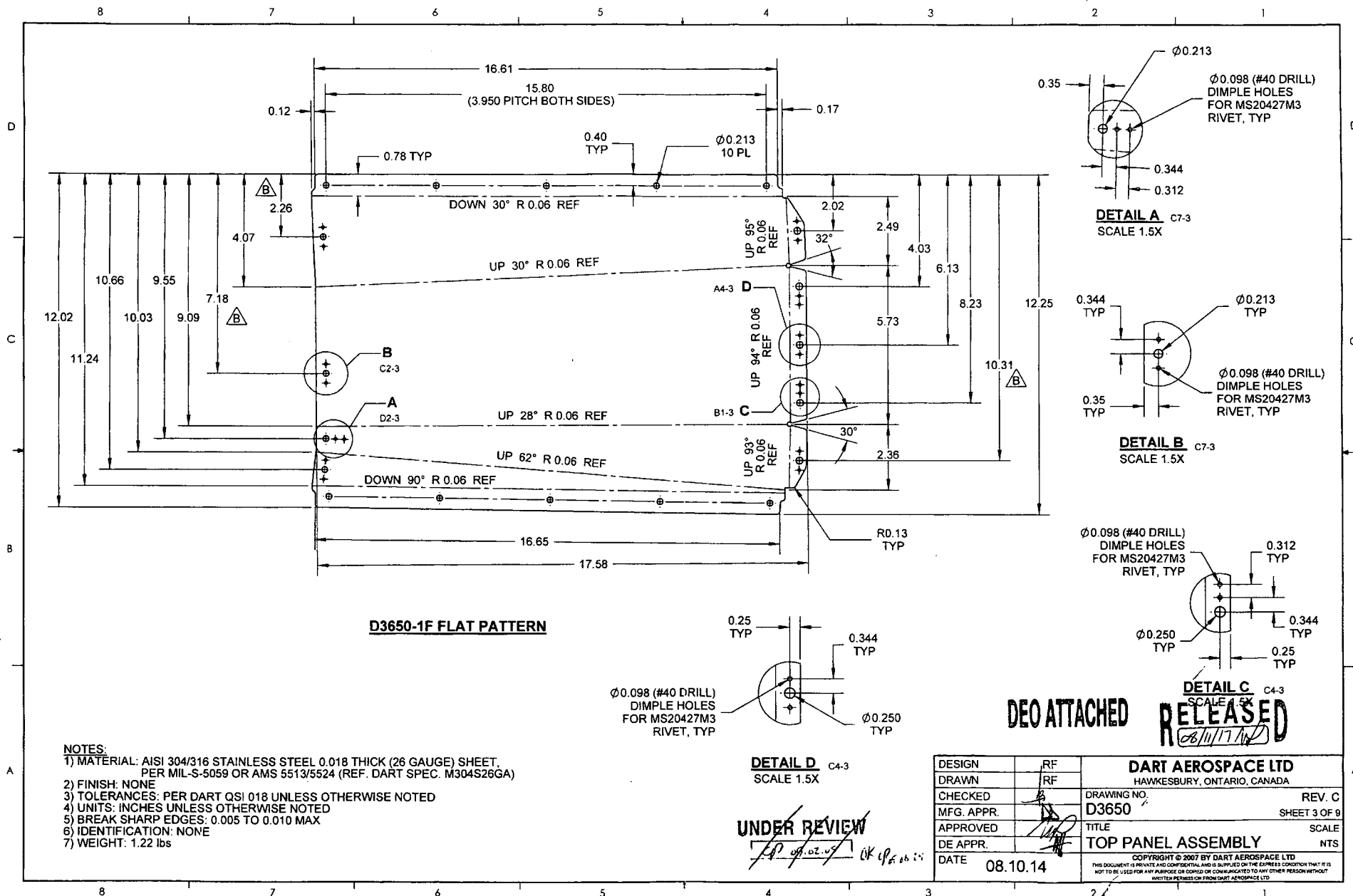
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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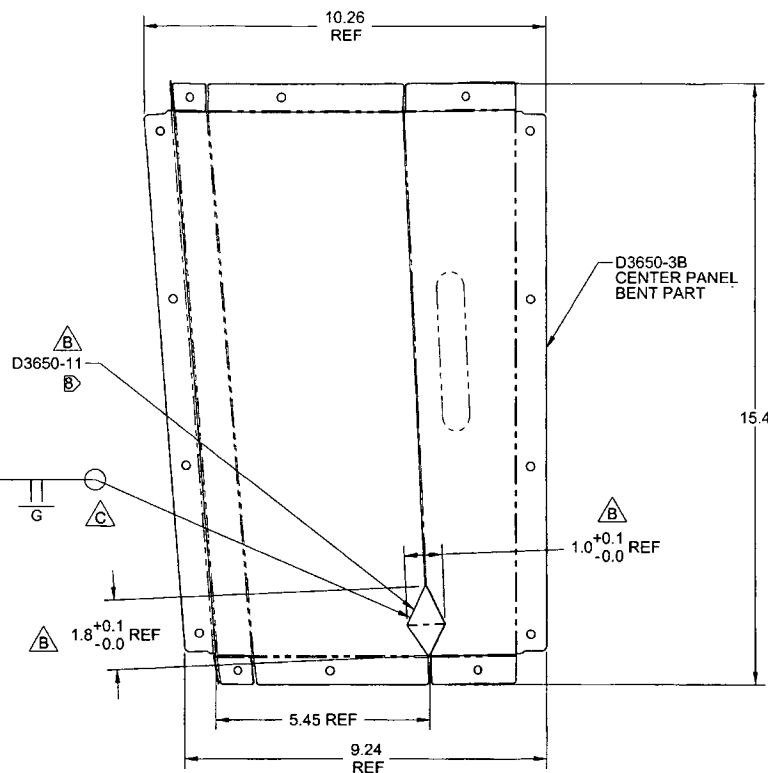
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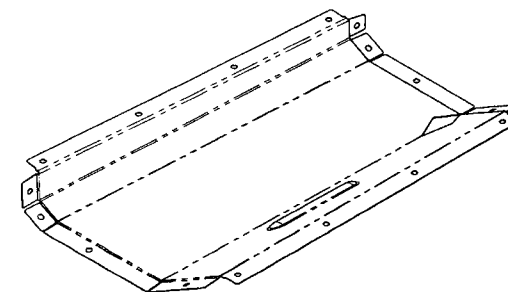
80408

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

IT IS ACCEPTABLE
TO GRIND & LEAVE
0.03 FROM BOTTOM
FLAT SURFACE



D3650-3 CENTER PANEL
(LOOKING FROM OUT SIDE SURFACE)



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

UNDER REVIEW

09.02.05
09.06.29

DEO ATTACHED

RELEASED
08.11.17

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3650	REV. C
MFG. APPR.			SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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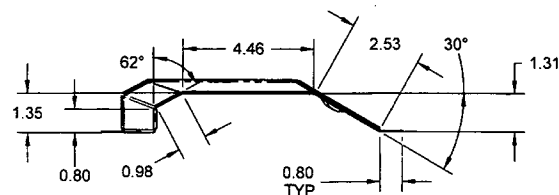
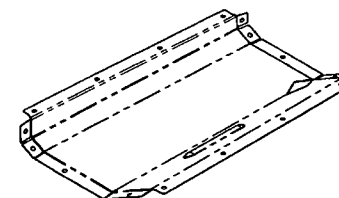
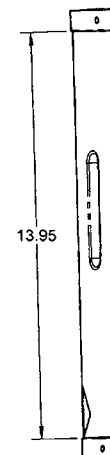
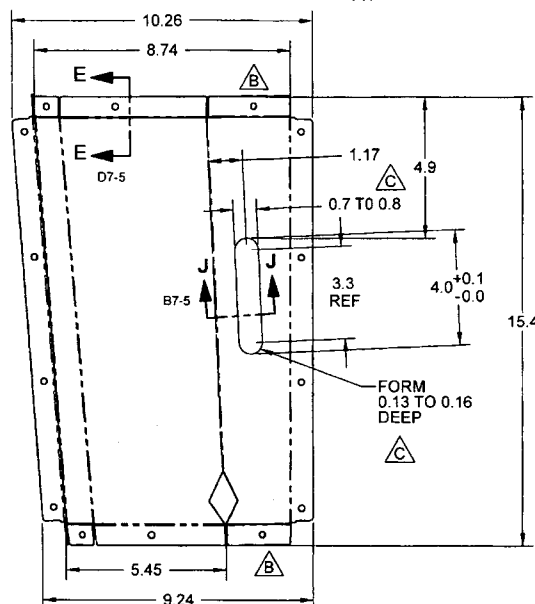
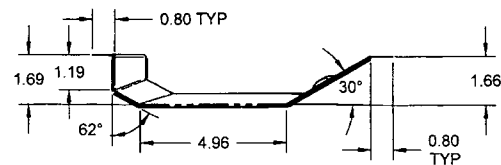
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NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
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337	338	339	340	341	342	343	344
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353	354	355	356	357	358	359	360
361	362	363	364	365	366	367	368
369	370	371	372	373	374	375	376
377	378	379	380	381	382	383	384
385	386	387	388	389	390	391	392
393	394	395	396	397	398	399	400
401	402	403	404	405	406	407	408
409	410	411	412	413	414	415	416
417	418						



D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

~~UNDER REVIEW~~

DESIGN	RF	DART AEROSPACE LTD 110 KAWESBURY, ONTARIO, CANADA DRAWING NO. D3650 TITLE TOP PANEL ASSEMBLY COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS ISSUED UNDER THE FOLLOWING CONDITIONS: 1. NO PART OF THIS DOCUMENT OR ITS CONTENTS MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. 2. THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR CORP OR COMMUNICATED TO ANY OTHER PERSON OR COMPANY WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	REV. 0
DRAWN	RF		SHEET 5 OF 5
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 08/11/17 BY [signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3650-3F CENTER PANEL FLAT PATTERN

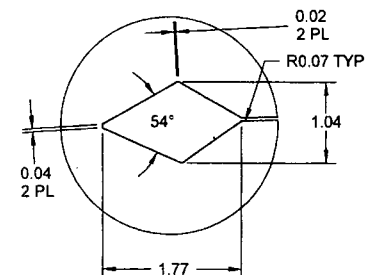
D3650-3F NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA).
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

DEO ATTACHED

RELEASED
06/11/17

DESIGN		RF	DRAWING NO. D3650	REV. C SHEET 6 OF 9
CHECKED	B	RF		
MFG. APPR.	[Signature]		TITLE TOP PANEL ASSEMBLY	SCALE NTS
APPROVED	[Signature]		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.10.14			

UNDER REVIEW
OK 09.02.15
OK 09.02.15



C5-6 **DETAIL K**
SCALE 2X

DEO ATTACHED

- 1 DOWN 92° R 0.015
- 2 DOWN 89° R 0.015
- 3 DOWN 86° R 0.015
- 4 UP 90° R 0.015
- 5 UP 88° R 0.015
- 6 UP 90° R 0.015
- 7 DOWN 88° R 0.015
- 8 DOWN 90° R 0.015
- 9 DOWN 94° R 0.015


RELEASED
08/11/17

D3650-3F CENTER PANEL FLAT PATTERN

D3650-3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

~~UNDER REVIEW~~

DESIGN	RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		DRAWING NO. D3650	
CHECKED			REV. 6	
MFG. APPR.			SHEET 6 OF	
APPROVED			SCALE	
DE APPR.			NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

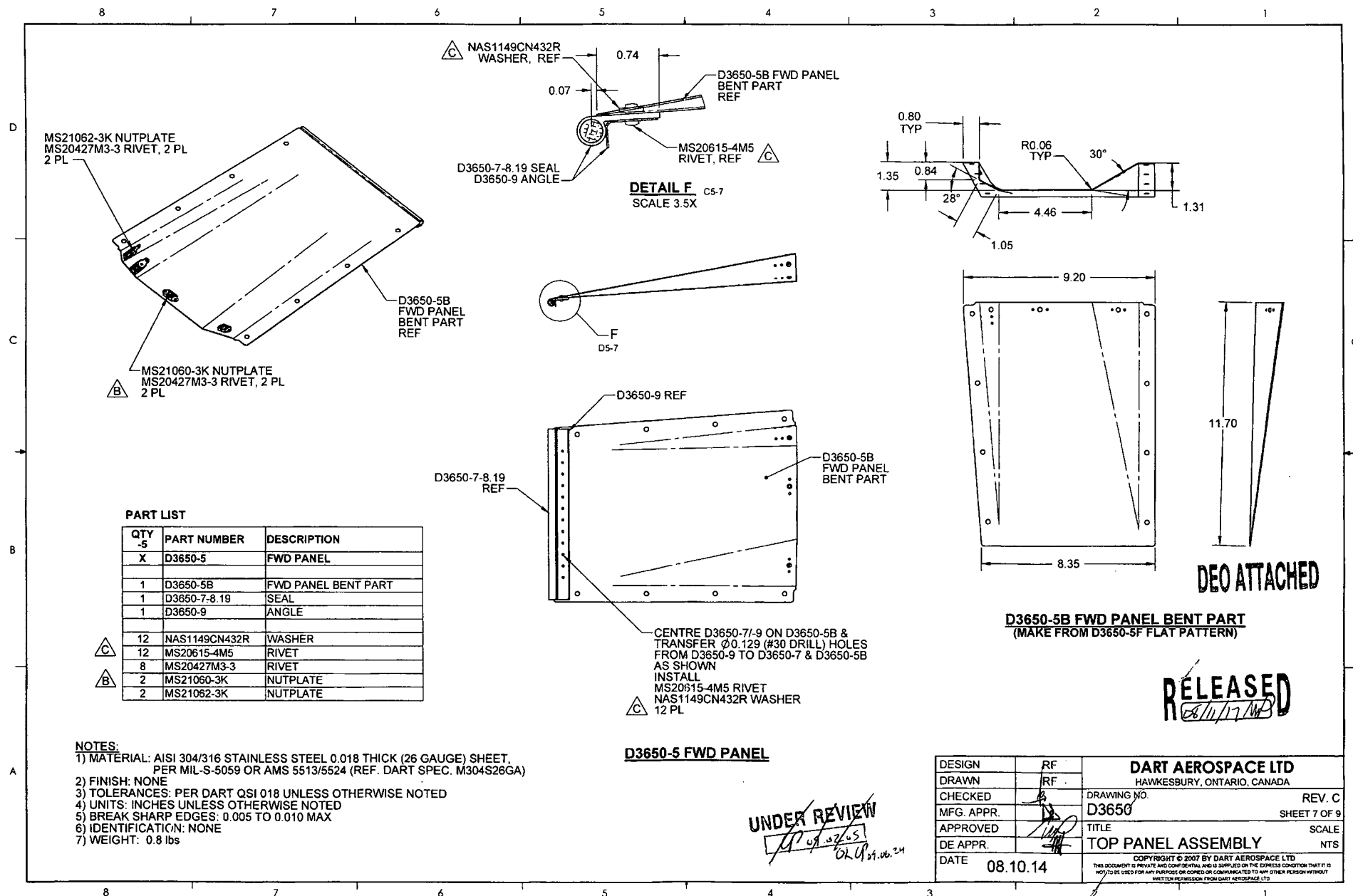
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80408



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

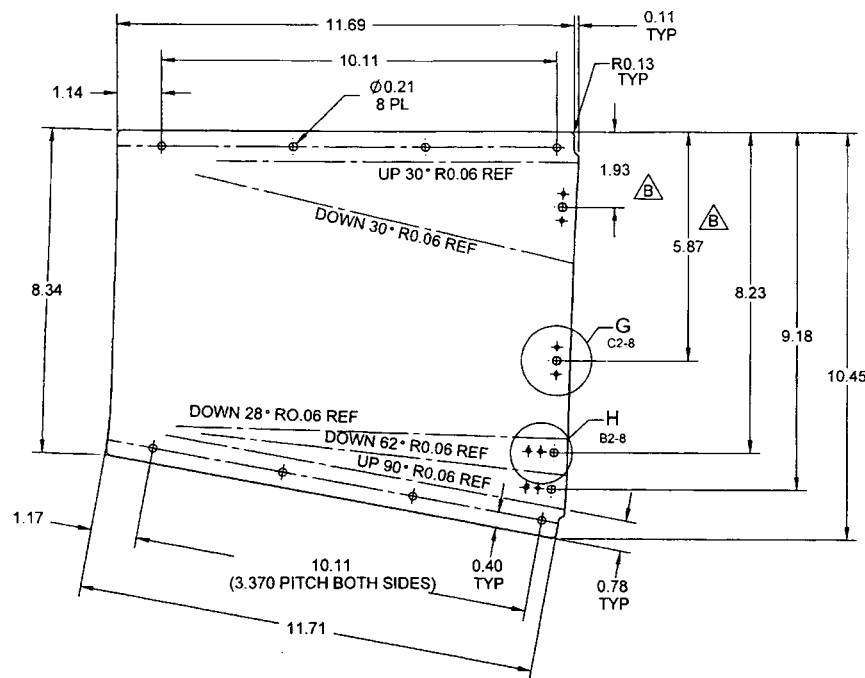
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

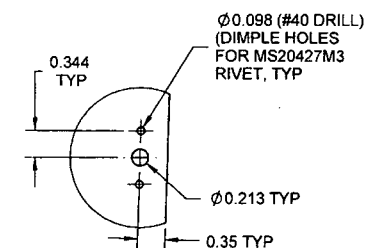
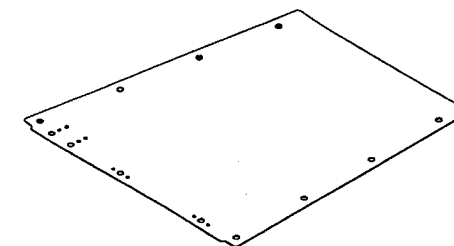
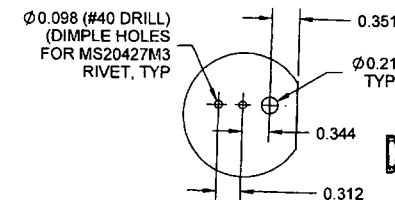
NOTE: Date & initial all entries

80408

**D3650-5F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

UNDER REVIEW
[Signature]
 08.10.14

**DETAIL G**
2 PL
SCALE 1.5X**DETAIL H**
2 PL
SCALE 1.5X**DEO ATTACHED****RELEASED**
08/11/17

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3650	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 8 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOP PANEL ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

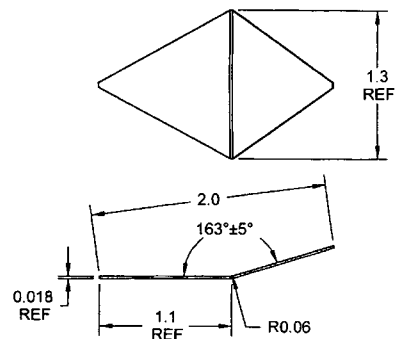
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

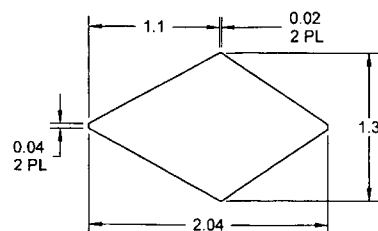
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80408



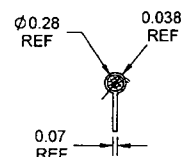
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



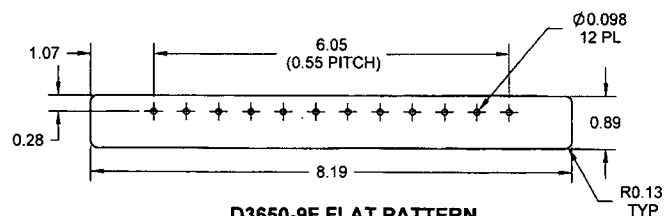
D3650-11F FLAT PATTERN



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

UNDER REVIEW
OK 4/11/14

DEO ATTACHED

RELEASED
08/11/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	D	D3650	SHEET 9 OF 9
APPROVED	4/11/14	TITLE	SCALE
DE APPR.	4/11/14	TOP PANEL ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries